

83323

Tuesday, April 17, 2012 1:16:38 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/17/2012 **Start Qty:** 40.00

40

Required Date: 4/25/2012 **Req'd Qty:** 40.00

40

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:**

Date: 12-04-17

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

[illegible]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83323

Tuesday, April 17, 2012 1:16:38 PM

83323

Page 2

Item ID: D2876

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle Spacer

Start Date: 4/17/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Small Fab

Small Fab

Memo

0.00

Small Fab

Remove tabs and Tumble

u/45

140

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

150

150

QC

Quality Control

QC - Inspect Part Finish

Memo

0.00

0.00

40
x coat

d ll u/05/12

40 d

6/12-5-H.

Dart Aerospace Ltd

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NOTE: Date & initial all entries

83323

Tuesday, April 17, 2012 1:16:38 PM

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

40

40

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

160

Packaging

Memo

0.00

Packaging

0.00

170

QC

Memo

0.00

Quality Control

12/5/15 ~~7~~
mf
12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, April 17, 2012 1:16:41 PM

Work Order ID: 83323

83323

Parent Item: D2876

D2876

Parent Item Name: Saddle Spacer

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: ESR Rev:B00.05.19Added inspect level 8EC

IPP Rev:C Now M6061-T6 06-06-23

JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.100

Purchased

No

100

sf

76.4000

0.0516

2.172632

M6061T6S 100******

6061-T6 .100 Sheet

LocationLoc QtyLoc Code

MAT021

76.4

102201

1

118072

12.4

118523

63

118072Jm/DA
12-5-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Dart Aerospace Ltd

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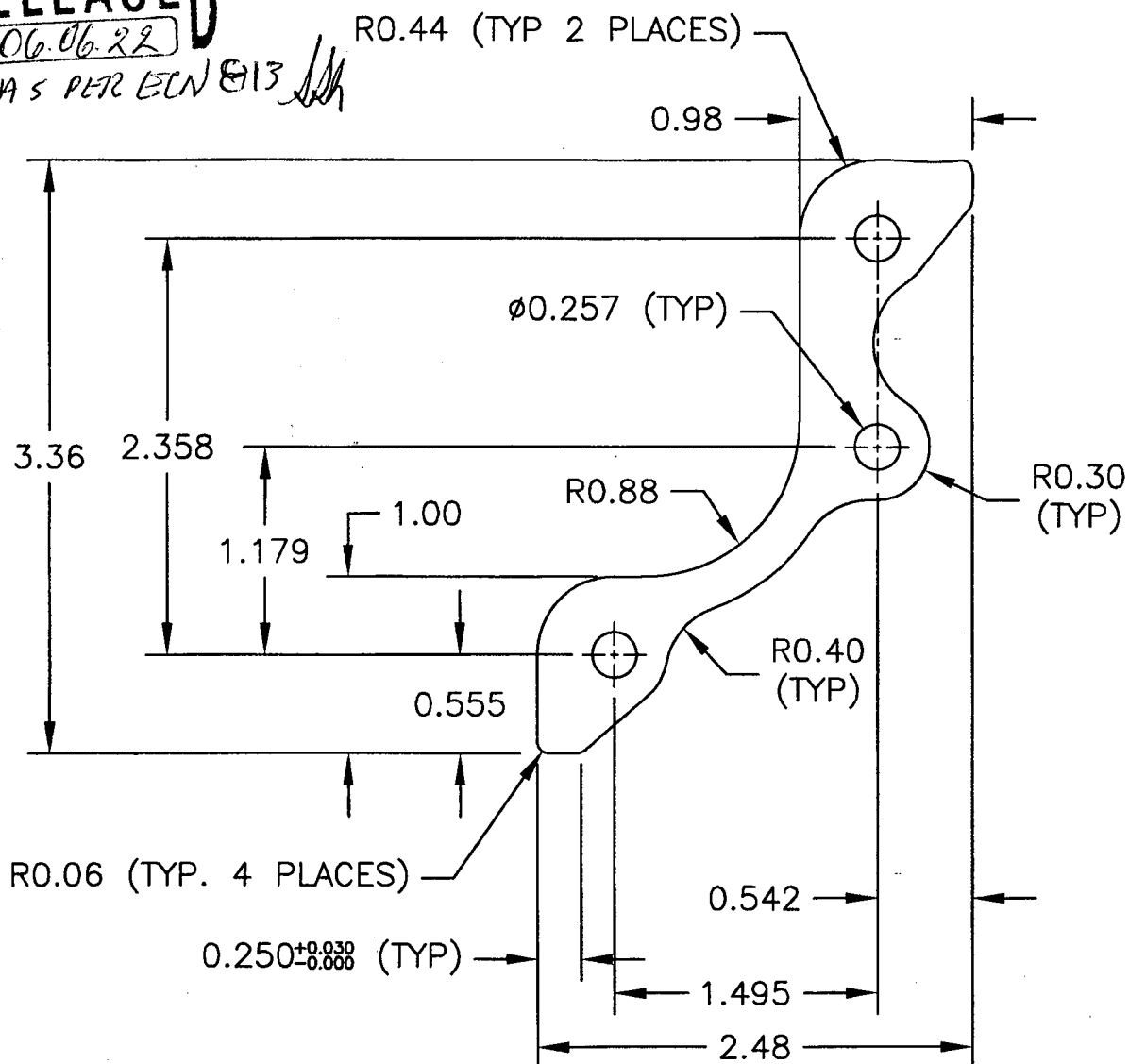
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. B SHEET 1 OF 1
DATE 06.06.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.06.02	MATERIAL CHANGE	

RELEASED
06.06.22

AS PER ECN 813 *[Signature]*



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *83325*

12-04-17

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